

# Work Order ID 103848

**\*103848\***

Page 1

July-03-13 9:23:04 AM

Item ID: D2563      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Step Weldment Assembly  
 Start Date: 7/03/13      Start Qty: 4.00      **\*4\***      Cust Item ID:  
 Required Date: 7/19/13      Req'd Qty: 4.00      **\*4\***      Customer:  
 Reference:

Approvals:      Process Plan: W      Date:      Tooling:      Date:      Run Start **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2563	Rev C								
100	Large Fab	0.00							
<b>*100*</b>									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2244 to 89.70" at 34 deg as per dwg D2563								
	2-Deburr ends								
	3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343								
	4- Grind								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

42 4 13-09-30 PD

CPL 13-10-08

4x

# Work Order ID 103848

**\*103848\***

Page 2

July-03-13 9:23:04 AM

Item ID: D2563      Accept      **\*N900040100\***      Setup      Start      **\*NS1\***  
Revision ID:      Stop      **\*NS2\***  
Item Name: Step Weldment Assembly  
Start Date: 7/03/13      Start Qty: 4.00      **\*4\***      Cust Item ID:  
Required Date: 7/19/13      Req'd Qty: 4.00      **\*4\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	CPC 13-10-08			4			
130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4			13-10-11
140 <b>*140*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				4	0		DAS 19 13-10-16

# Work Order ID 103848

**\*103848\***

Page 3

July-03-13 9:23:04 AM

Item ID: D2563 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Weldment Assembly  
 Start Date: 7/03/13 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 7/19/13 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>123928</u> Large Fab  Memo  1-Inspect for foreign object per QSI 024  2-Weld Remainig End cap as per Dwg D2563 using DT 8343  3-Grind	0.00  0.00				4	0		DAS 19 9-89 13-10-16
160 <b>*160*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				4			DAS 27 9-89 B10/15
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				4			DAS 27 9-89 B10/16

# Work Order ID 103848

July-03-13 9:23:04 AM

**\*103848\***

Page 4

Item ID: D2563 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Weldment Assembly  
 Start Date: 7/03/13 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 7/19/13 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175	Pressure Wash per QSI005 4.3	0.00				4		7/13/105	
<b>*175*</b>	HandFinish	0.00							
Hand Finishing	Memo Touch up Alodine as per QSI005								
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				4		13-10-16.	
<b>*180*</b>	Powdercoat	0.00							
Powder Coating	Memo Touch up Alodine then Powder Coat White Gloss (Ref:4.3.5.1) as per QSI 005 4.3								
	START TIME: 10:00 OVEN TEMPERATURE: 320° FINISH TIME: 10:30								
190	Wing Walk as per dwg QSI005 4.4 Batch M127105061					4		13/10/16	
<b>*190*</b>	HandFinish	0.00							
Hand Finishing	Memo								

DAS  
34  
9-89

**\*103848\***

July-03-13 9:23:04 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*4\***

**\*4\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**\*200\***

DAS  
27  
9-89

13.10.17

**\*210\***

PPS 107578<sub>0.00</sub>

**\*220\***

0.00

## Quality Control

1/3/24 (4)

9/11/13-10-28  
mE

MF  
13-10-25

# Picklist Print

July-03-13 9:23:03 AM

Page 1

Work Order ID: 103848

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 7/03/13

Required Date: 7/19/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116 STEP EXTRUSION		Manufactured	No			100	Each	53.2105	1	4		13-09-26	PD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		-0.0000368			1049411 → (4)				
				WA003		53.2104894							
				60307		2							
				80803		17.2104894							
				89954		34							
D2561 Lug		Manufactured	No			100	Each	34.0000	2	8		13-09-26	PD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		34			104831 → (8)				
				66813		5							
				99027		29							
D2564 Mounting Angle		Manufactured	No			100	Each	57.0000	2	8		13-09-26	PD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		17							
				99050		17							
				WA003		40							
				99527		40			(3)				
D2673-34 End Plate		Manufactured	No			100	Each	108.0000	1	4		13-09-26	PD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		108							
				103377		100			(4)				
				97990		8							

# Picklist Print

July-03-13 9:23:03 AM

Page 2

Work Order ID: 103848

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 7/03/13

Required Date: 7/19/13

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured

No

150

Each

108.0000

1

4

End Plate

113.10.16

Location

Loc Qty

Loc Code

WA003

108

103377

100

97990

8

4

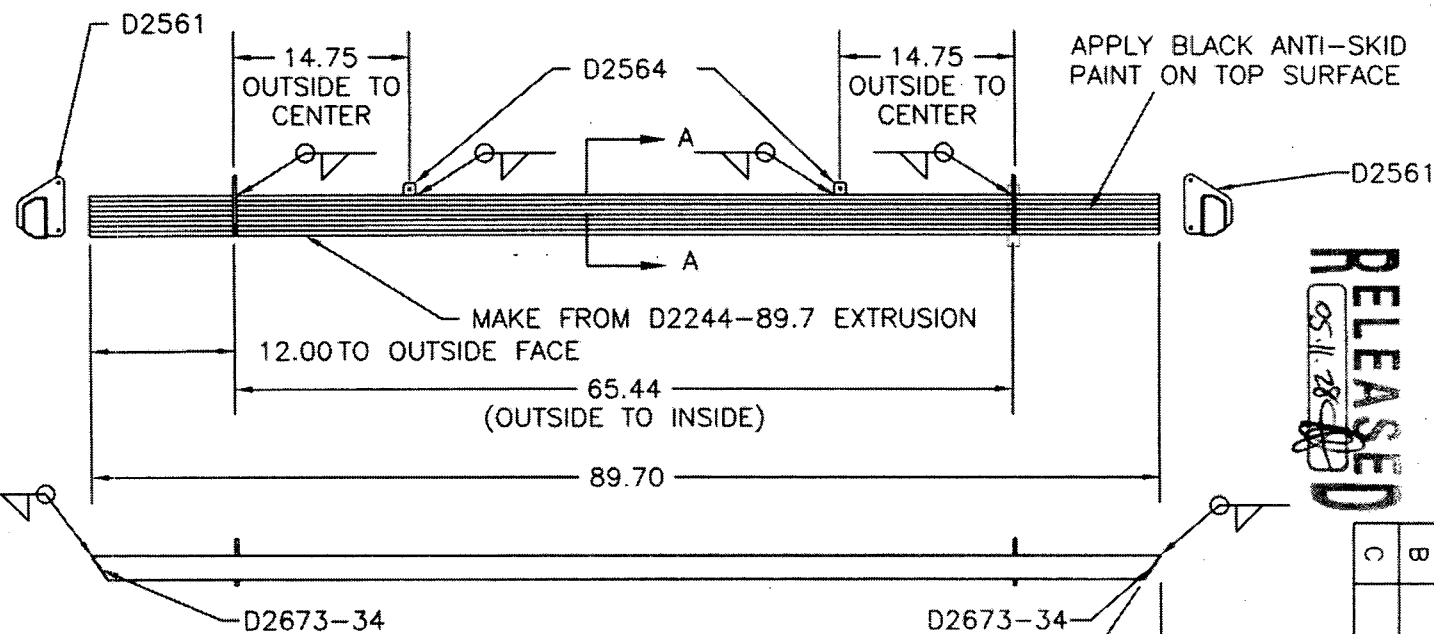
July-03-13 9:23:03 AM

Shop Packet Print

Page 2



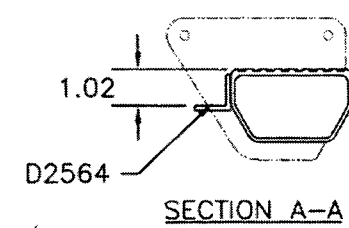
RELEASED  
05.11.28



**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

\*cut per drawing



**D2563 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY
A	96.04.26	NEW ISSUE	REV. C
B	97.05.14	END CAPS CHANGED (WAS D2248)	SHEET 1 OF 1
C	05.11.14	UPDATE NOTES	SCALE 1:1.5

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 1996 by DART AEROSPACE LTD